

Date: Tuesday, 4/18/2006 10:06:30 AM
 User: Kim Johnston

Process Sheet

21

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT SKIDTUBE ASSEMBLY
Job Number : 26682	
Estimate Number : 10309	
P.O. Number : N/A	Part Number : D206642541
This Issue : 4/18/2006 S.O. No. : N/A	Drawing Number : D3274 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : C
Previous Run : 26680	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 5/19/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 06.04.18	
Comment : Est Rev: B 05.09.23 Revised per D206-642 Rev. J KJ/JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0

DC

DOCUMENT CONTROL



KJ 05.02.28

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-541

CHG001

PH

CHG 002 07.03.15

2.0

D26001240

Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-240 3" OD Tube

310427

BE 06-05-29 (1)

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

BE 06-05-29 (1)

2-Drill #40-Aft cap pilot hole using DT8025

BE 06-05-29 (1)

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

BE 06-05-29 (1)

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

BE 06-05-29 (1)

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BE 06-05-29 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 06-5-29

6.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B25435 BE 06-05-29

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

BE 06-05-29

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

BE 06-05-29

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

BE 06-05-29

4-Bond web in place as per Dwg D3274 & QSI 015.

A/R : Sikaflex-291

M100901 BE 06-05-29

Sikaflex expire date:

11/2006

Start:

5:00

Time: 06-05-29

Finish:

7:30

Time: 06-05-30

BE 06-05-30

(Adhere for 12 hours)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-5-30

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Job Number: 26682

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .1875

5- C'SINK WITH 3/16 C'SINK BIT (ENSURE NOT TO C'SINK TO DEEP)

6- OPEN HOLES TO .257 AS PER DRWG D3274

7- FINISH C'SINK WITH .257 C'SINK BIT (ENSURE NOT TO C'SINK PAST THE BOTTOM, ONLY CUT THE TOP) AND INSPECT C'SINK WITH A SAMPLE NAS1330C3KB116 INSERT TO ENSURE INSERTS WILL SIT FLUSH, AND HOLE IS NOT OVERSIZED

8- DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

9- Countersink crossbolt spacer holes as per Dwg D3274

10.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3285-1

Fwd Cap

B21744 BE 06-06-01

11.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

B25864 BE 06-06-01

W/O:		WORK ORDER CHANGES					
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Job Number: 26682

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

B21748 BE 06-06-01

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod M19101 / M18839 BE 06-06-01

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod M18839 BE 06-06-01

3-Grind welds flush to Fwd cap on top surface only. BE 06-06-01

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube BE 06-06-01

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr. BE 06-06-07

14.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141 M103141 07-03-05 (1)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

O.N. 07/03/08 (1)

17.0

D3415041



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041

Nut Plate

B24574

FR/

07/03/08 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 26682

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CCR264SS33

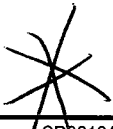
Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CCR264SS3-3 Rivet m101334



19.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CR3212-4-03 Rivet m15918

20.0

D26483

Wearpad



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch
9 D2648-3 Wearpad B29777

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-15 Wearshoe B28694

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-23 Wearshoe B29336

07-03-128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 26682

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe B29337

24.0

D32871

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3287-1 Wearshoe B20889

25.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B30237

26.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer M103344

27.0

MS27039C108

SCREW



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 MS27039C1-08Screw M19185

28.0

NAS1330C3KB116

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1330C3KB116 Inserts M19849

MS 07-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26682

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

NAS1515H3L

WASHER



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1515H3L Washer M103641

30.0

D34131



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring ~~B 24222~~ B 24222 MS

31.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M18919

32.0

AN960C416L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416L Washer M18822

33.0

NAS1515H4L

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 NAS1515H4L Washer M101542

34.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B 30119

MS 07-03-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 26682

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960C10L

Washer M103344

36.0

MS27039C108

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039C1-08Screw

M19185

37.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 NAS1515H3L

Washer M103641

07-03-09

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 M17168

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube.

A/R Sikaflex-291 M103497

Sikaflex expire date: 07-10

3-Install ring as per Dwg D3274

A/R Sikaflex-291 M103497

Sikaflex expire date: 07-10

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: M103345

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

07-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/19

QA: N/C Closed: _____ Date: _____

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Job Number: 26682

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

M103497

Sikaflex expire date:

07-10

HL 07-03-09

39.0

QC5

INSPECT WORK TO CURRENT STEP



0703.09



Comment: INSPECT WORK TO CURRENT STEP

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

0703/19

Job Completion



0703/16

41 package per fpp

REV B CU 7/3/15

42 DC21

W/O:		WORK ORDER CHANGES					
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. C SHEET 1 OF 4
DATE 05.03.16		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	

RELEASED
05-09-06 [Signature]

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
9	9	D2648-3	WEARPAD
12	12	D2649	CROSS BOLT SPACER
1	1	D2656-15	WEARSHOE
1	1	D2656-23	WEARSHOE
1	1	D2656-35	WEARSHOE
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3287-1	WEARSHOE
1	1	D2646	AFT CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3429-1	WEARPAD
78	78	NAS1330C3KB116	INSERT
80	80	NAS1515H3L	WASHER
1	1	NAS1515H4	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
80	80	MS27039C1-08	SCREW
1	1	AN4C5A	BOLT

GENERAL NOTES:

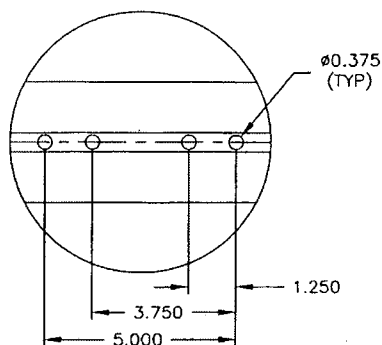
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL 'E' (Ø0.250 REF) AND C'SINK Ø0.391x100° FOR NAS1330C3KB116 INSERT USING DT3274-1T2 BEFORE FINISH. INSTALL NAS1330C3KB116 INSERTS AFTER FINISH WITH LPS LABORATORIES "LPS-3".
8. WEARPLATES TO BE INSTALLED WITH A LAYER OF SIKAFLEX-241/-291 ADHESIVE BETWEEN WEARPLATES AND SKIDTUBE.
9. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DESGREASER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26682

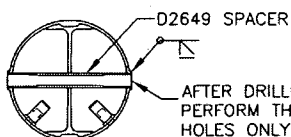
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DETAIL A: DRILL DETAIL

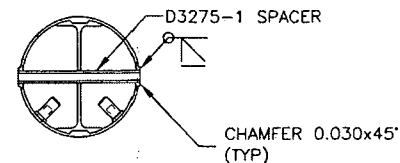


DETAIL B FOR 0.375 HOLES ONLY

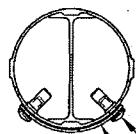


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C-BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY

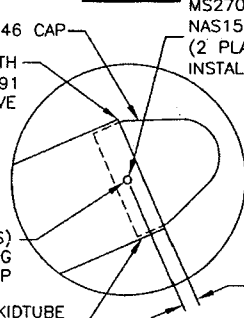


DETAIL D



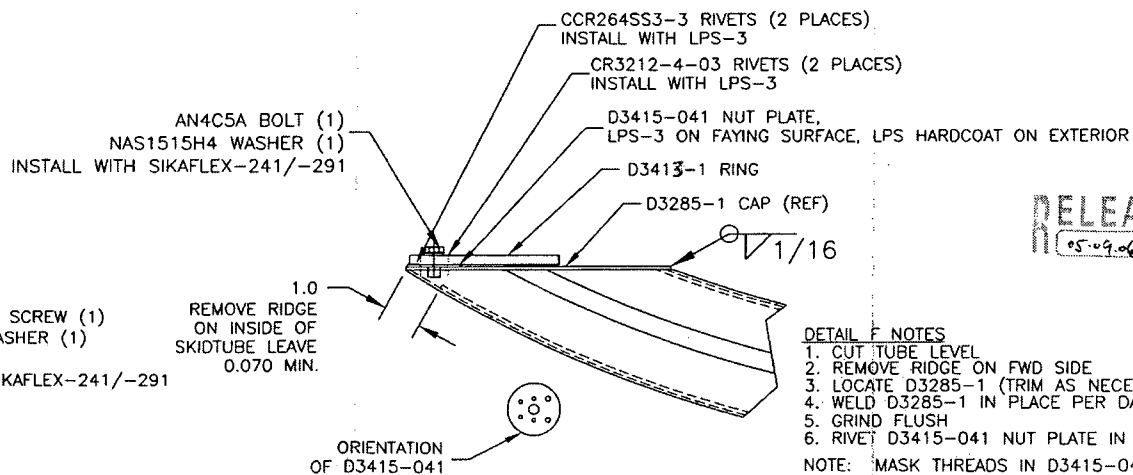
- NAS1330C3KB116 INSERT (1)
MS27039C1-08 SCREW (1)
NAS1515H3L WASHER (1)
(78 PLACES)
WEARPAD/WEARSHOE (REF)

DETAIL E



- 0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP
BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



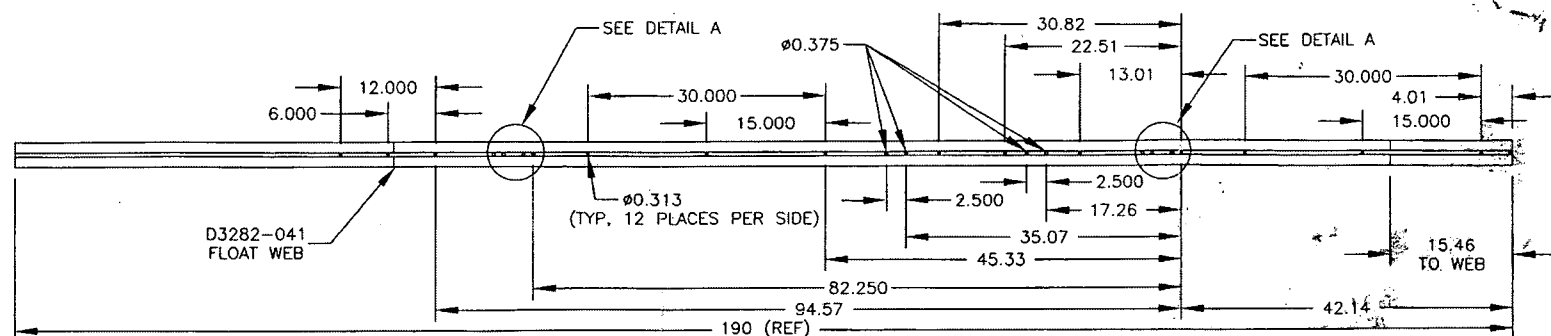
DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
05-09-06

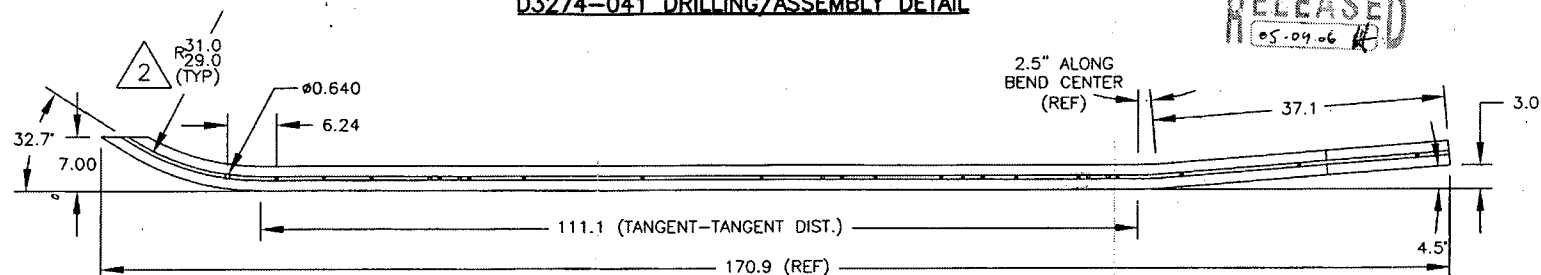
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		#	#	D3274	SHEET 2 OF 4
		DATE		TITLE	SCALE
		05.03.16		SKIDTUBE ASSEMBLY	1 TO 3

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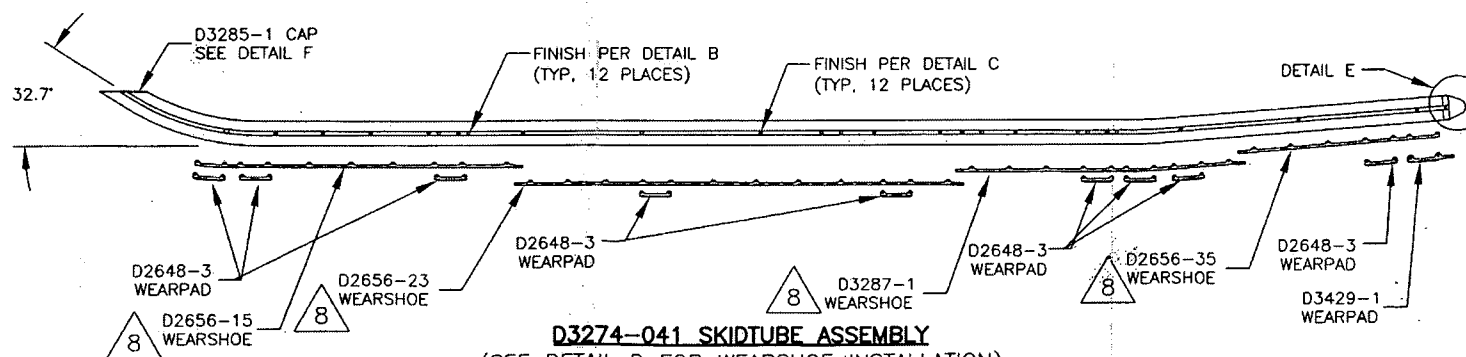


D3274-041 DRILLING/ASSEMBLY DETAIL

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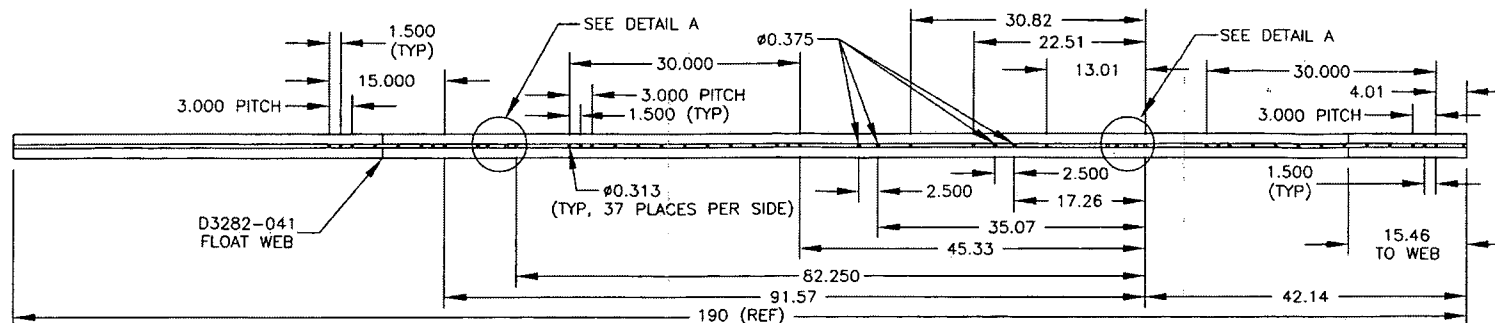
D3274-041 BEND/DRILLING DETAIL



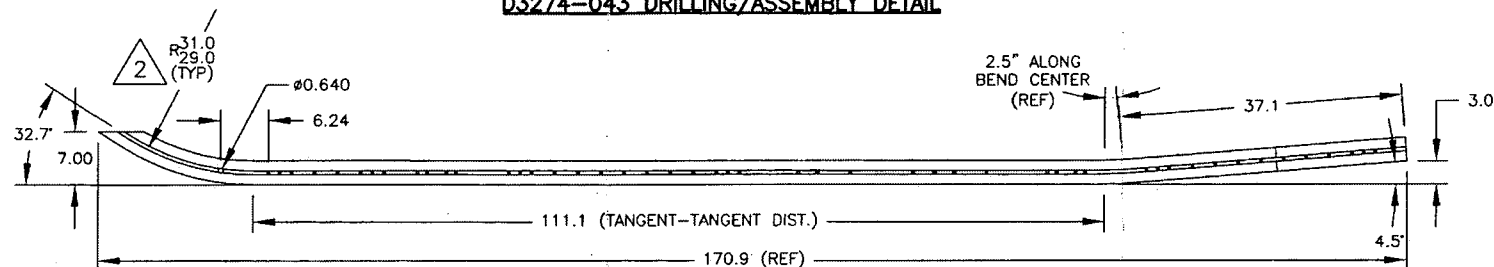
D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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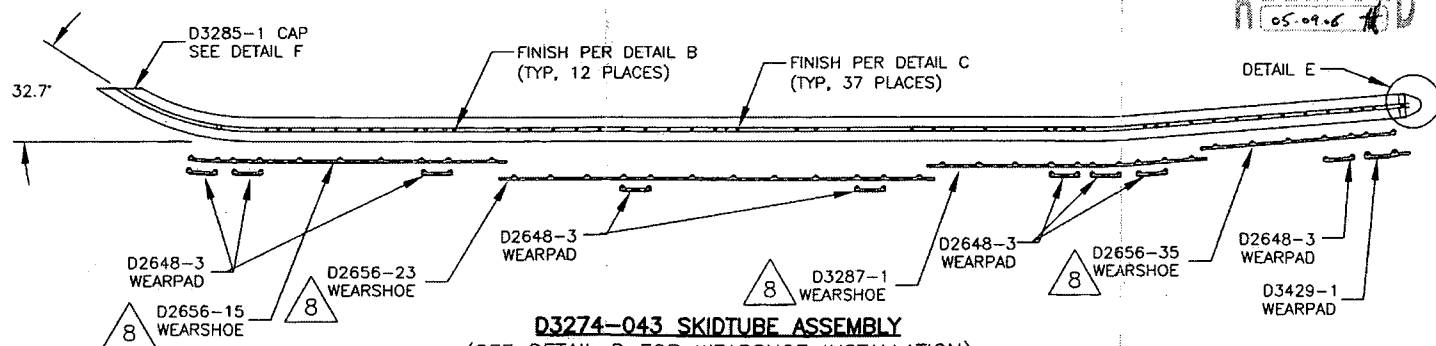
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D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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